

Work Order ID 51512

August 25, 2009 1:34:27 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 8/24/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/24/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *KL*

Date: *09-8-25* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

NA

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend I

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

(IX)

2

MR 09-08-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

1 / 0 - AUM 9-8-3

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 S 08/24/31

20 / 0

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Item Name: Replacement Skidtube

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Setup Start



Stop



Start Date: 8/24/09 Start Qty: 1.00
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Cust Item ID:
Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R: [] Aluminum Rod

mill 682

BE 09/08/31

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R: [] Aluminum Rod

mill 682

BE 09/08/31

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

BE 09/09/09

| W/O: | | WORK ORDER CHANGES | | | | | |
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

0.00

2) 8/24/09

(X1)

Ø

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O S

Memo

0.00

0.00

2) 8/24/09

(X1)

Ø

170



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

0.00

0.00

11 08/09/14

(X1)

Ø

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Setup Start

Stop

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Required Date: 8/24/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:30 AM
320°F
9:00 AM

0.00

Powder Coating

190

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

0.00

M112260
09/09/15
(X1)
BR 0909-16.
D.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R [] [] [] [] Sikaflex-291
Sikaflex expire date: 10/20 m112391

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R [] [] [] [] Sikaflex-291
Sikaflex expire date: 10/20 m112391

5-Wing Waik as per Dwg D2580 and QSI 005 4.4
Batch: m112106

(X1)

MD 09/09/16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Work Order ID 51512

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Item ID: D205-634-041

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Setup Start



Revision ID: D

Item Name: Replacement Skidtube

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Start Date: 8/24/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/24/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

8/25/09

Memo

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024



220



Packaging

Packaging

Packaging

0.00

0.00

Memo

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev:

PT 51268

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10 9/2/23 ①

09/09/23
MF 09-09-23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51512

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Start Date: 8/24/09

Required Date: 8/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

D2580-1RevD

Manufactured

No

110

Each

14.0000

1.0000



205 Skidtube bent detail



B-51476 MS 09-08-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

13

50757

3

50761

6

50976

2

50977

2

Main Warehouse

ST

1

50758

1

D2576-3RevG

Manufactured

No

140

Each

141.0000

1.0000



Step (maching detail)



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

141

43504

40

46661

101

1 BE 09/08/31

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Picklist Print

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Work Order ID: 51512

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2579RevE | | Manufactured | No | | | 140 | Each | 464.0000 | 20.0000 | | | |



Crossbolt Spacer

| Warehouse Location | Loc Qty | Loc Code |
|-----------------------|---------|----------|
|-----------------------|---------|----------|

Main Warehouse

| | | |
|-------|-----|--|
| ST | 464 | |
| 43988 | 4 | |
| 46434 | 4 | |
| 46956 | 2 | |
| 47797 | 9 | |
| 48272 | 22 | |
| 51314 | 100 | |
| 51315 | 323 | |

51315 (20) 09/08/31

D2855RevA

Manufactured No

200

Each

29.0000

1.0000



Cap

| Warehouse Location | Loc Qty | Loc Code |
|-----------------------|---------|----------|
|-----------------------|---------|----------|

Main Warehouse

| | | |
|----------------|----|--|
| FP | -1 | |
| 50513 | -1 | |
| Main Warehouse | | |
| FP6 | 31 | |
| 50513 | 31 | |
| Main Warehouse | | |
| ST | -1 | |
| 50513 | -1 | |

(X1) mp 09/09/10

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Shop Packet Print

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| AN3-5A | | Purchased | No | | | 200 | Each | 2,515.000 | 2.0000 | | | |



Bolt

| Warehouse Location | Loc Qty | Loc Code |
|-----------------------|---------|----------|
|-----------------------|---------|----------|

Main Warehouse

| | | |
|----|------|--|
| ST | 2515 | |
|----|------|--|

| | | |
|--------|-----|--|
| 100188 | 212 | |
|--------|-----|--|

| | | |
|--------|------|--|
| 105057 | 2245 | |
|--------|------|--|

| | | |
|-------|----|--|
| 15205 | 58 | |
|-------|----|--|

X2 MD 09/09/16

AN960JD10L

Purchased

No

200

Each

6,679.000

2.0000



Washer

| Warehouse Location | Loc Qty | Loc Code |
|-----------------------|---------|----------|
|-----------------------|---------|----------|

Main Warehouse

| | | |
|----|----|--|
| FP | -2 | |
|----|----|--|

| | | |
|--------|----|--|
| 109632 | -2 | |
|--------|----|--|

Main Warehouse

| | | |
|----|------|--|
| ST | 6681 | |
|----|------|--|

| | | |
|--------|----|--|
| 101291 | 16 | |
|--------|----|--|

| | | |
|--------|-----|--|
| 104885 | 153 | |
|--------|-----|--|

| | | |
|--------|-----|--|
| 105793 | 236 | |
|--------|-----|--|

| | | |
|--------|------|--|
| 109632 | 1276 | |
|--------|------|--|

| | | |
|--------|------|--|
| 110985 | 5000 | |
|--------|------|--|

X2 MD 09/09/16

August 25, 2009 1:34:27 PM

Shop Packet Print

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Work Order ID: 51512

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| ALS7-1032-130 | | Purchased | No | | | 200 | Each | 3,628.000 | 50.0000 | | | |



Insert

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 3628

105855 16

108606 52

111529 1560

111779 2000

AN3C4A

Purchased

No

200

Each

632.0000

50.0000



BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP -50

112314 -50

Main Warehouse

ST 682

112082 30

112314 652

112612

X50 MD 09/09/16

X50 MD 09/09/16

August 25, 2009 1:34:27 PM

Shop Packet Print

Page 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:34:27 PM

Page 5

Work Order ID: 51512

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| AN960C10L | | Purchased | No | | | 200 | Each | 2,946.000 | 50.0000 | | | |



washer

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

FP

-50

112116

-50

Main Warehouse

ST

2896

112116

2896

D3566-13RevC

Manufactured

No

200

Each

20.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

-1

48166

-1

Main Warehouse

ST

21

45717

1

46889

1

48166

3

50265

16

XSD mo 09/09/16

XI mo 09/10/16

August 25, 2009 1:34:27 PM

Shop Packet Print

Page 5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:34:27 PM

Page 6

Work Order ID: 51512

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3566-5RevC | | Manufactured | No | | | 200 | Each | 17.0000 | 1.0000 | | | |



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP19

-1

51260

-1

Main Warehouse

ST

18

36113

1

46186

1

47318

1

48167

1

51260

14

x1 mb 09/09/16

D3566-1RevC

Manufactured No

200

Each

27.0000

2.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

-2

51259

-2

Main Warehouse

ST

29

46349

1

47434

2

51218

1

51259

25

x2 mb 09/09/16

August 25, 2009 1:34:27 PM

Shop Packet Print

Page 6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 51512

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3564-11RevD | | Manufactured | No | | | 200 | Each | 29.0000 | 1.0000 | | | |



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

22

51256

22

Main Warehouse

FP19

-1

50112

-1

Main Warehouse

ST

8

45823

1

50112

7

XI MD 09/09/16

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Shop Packet Print

Page 7

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 51512

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3564-I3RevD | | Manufactured | No | | | 200 | Each | 30.0000 | 1.0000 | | | |



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP17

17

50270

17

Main Warehouse

FP19

-1

50270

-1

Main Warehouse

ST

14

45409

3

46495

10

47867

1

XI MD 09/10/09/16

August 25, 2009 1:34:27 PM

Shop Packet Print

Page 8

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 51512

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3564-9RevD | | Manufactured | No | | | 200 | Each | 20.0000 | 1.0000 | | | |


Wearshoe

| Warehouse Location | Loc Qty | Loc Code |
|-----------------------|---------|----------|
| Main Warehouse | 51675 | |
| FP19 | -2 | |
| 51258 | -2 | |
| Main Warehouse | | |
| ST | 22 | |
| 44659 | 1 | |
| 45825 | 1 | |
| 51258 | 20 | |

X1 MD 09/09/16

D3564-5RevD Manufactured No


Wearshoe

| Warehouse Location | Loc Qty | Loc Code |
|-----------------------|---------|----------|
| OFFSHORE | 51655 | |
| FG | 2 | |
| 34806 | 2 | |
| Main Warehouse | | |
| FP19 | 15 | |
| 48555 | 1 | |
| 51257 | 14 | |

X1 MD 09/09/16

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Shop Packet Print

Page 9

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:34:27 PM

Work Order ID: 51512

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2594-3RevC | | Manufactured | No | | | 200 | Each | 542.0000 | 16.0000 | | | |
|  | | | | | | | | | | | | |
| O-Ring, 205 Skidtube | | | | | | | | | | | | |

Warehouse Loc Qty Loc Code
Location

Main Warehouse

| | | |
|-------|-----|--|
| ST | 542 | |
| 27168 | 44 | |
| 29908 | 498 | |

D2594-1RevC

Manufactured No

200 Each 348.0000 16.0000



Plug, 205 Skidtube

Warehouse Loc Qty Loc Code
Location

Main Warehouse

| | | |
|-------|-----|--|
| ST | 348 | |
| 42221 | 16 | |
| 42807 | 92 | |
| 43884 | 3 | |
| 46435 | 2 | |
| 47251 | 235 | |

8/16 MD 09/09/16

8/16 MD 09/09/16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART

| | | | |
|------------------|----------------|--|------------------------|
| DESIGN # | DRAWN BY RH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D2580 | REV. D SHEET 1 OF 3 |
| DATE 07.02.27 | | TITLE 205 SKIDTUBE ASSEMBLY | SCALE NTS |
| A | 96.09.16 | NEW ISSUE | |
| B | 96.12.02 | AS MANUFACTURED | |
| C | 98.08.26 | REDRAWN, INCLUDED DEO 9094/9097 | |
| D | 07.02.27 | CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183 | |

RELEASED
07.06.28 #

| QTY -041 | QTY -045 | Part Number | Description |
|-------------|-------------|---|-------------------|
| X | | D2580-041 | SKIDTUBE ASSEMBLY |
| | X | D2580-045 | SKIDTUBE ASSEMBLY |
| 1 | 1 | D2500-1-190 | EXTRUSION |
| 1 | 1 | D2576-3 | STEP |
| 20 | 24 | D2579 | CROSS BOLT SPACER |
| 16 | 16 | D2594-1 | PLUG |
| 16 | 16 | D2594-3 | O-RING |
| 1 | 1 | D2596 | 205 WEB |
| 1 | 1 | D2855 | AFT CAP |
| 1 | 1 | D3564-5 | WEARSHOE |
| 1 | 1 | D3564-9 | WEARSHOE |
| 1 | 1 | D3564-11 | WEARSHOE |
| 1 | 1 | D3564-13 | WEARSHOE |
| 2 | 2 | D3566-1 | GASKET |
| 1 | 1 | D3566-5 | GASKET |
| 1 | 1 | D3566-13 | GASKET |
| 50 | 50 | ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130 | INSERT |
| 50 | 50 | AN3C4A | BOLT |
| 2 | 2 | AN3-5A | BOLT |
| 50 | 50 | AN960C10L | WASHER |
| 2 | 2 | AN960JD10L | WASHER |

21515

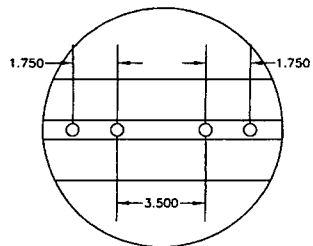
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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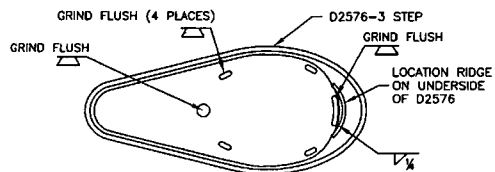
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DETAIL A
SCALE 5:24

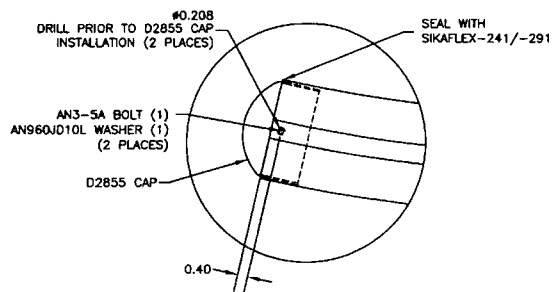


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07-06-28

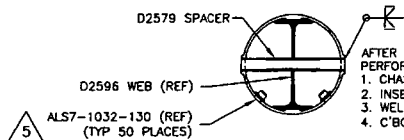
DETAIL B
SCALE 5:24



DETAIL C
SCALE 5:24



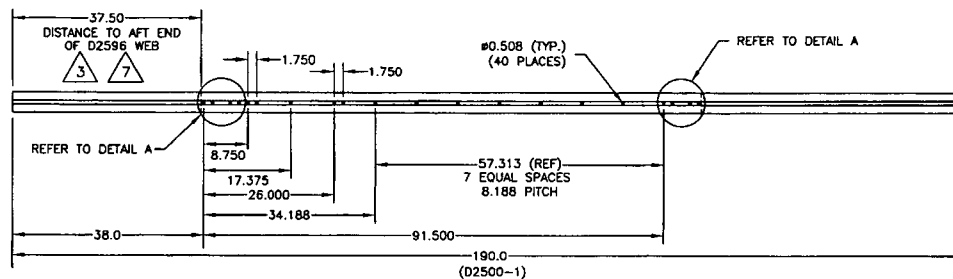
SECTION D-D
SCALE 5:24



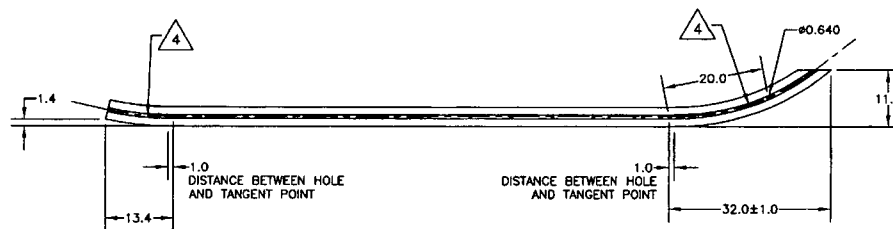
D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

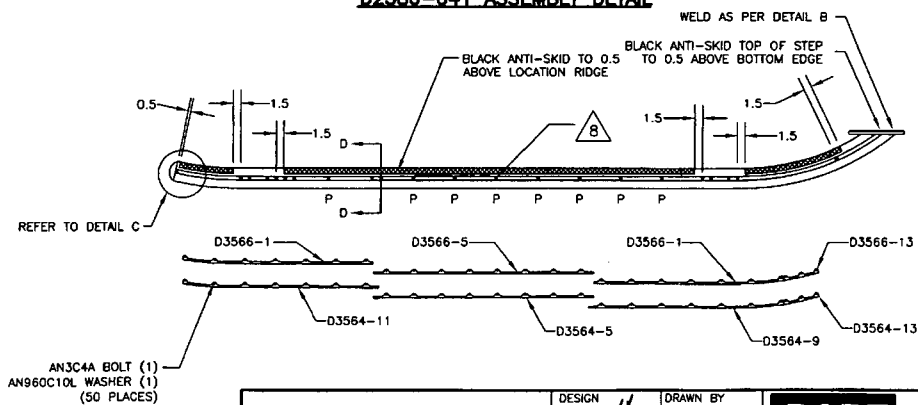
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



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| | |
|--------|----|
| DESIGN | 11 |
|--------|----|

CHECKED *11*

DATE _____

DRAWN BY

APPROVED *IL*

DART

DART AEROSPACE LTD.
HAMPSHIRE, ONTARIO, CANADA

| | |
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| DRAWING NO. | |
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D2580

| TITLE |
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REV

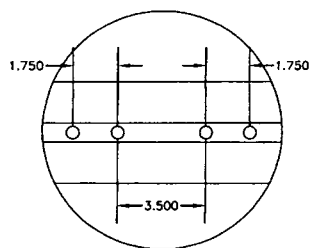
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REV. D

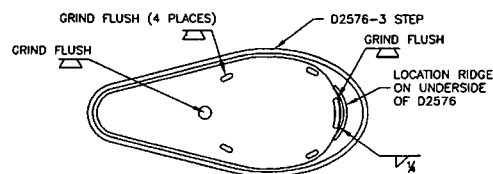
SHEET 2 OF 3

SCALE

DETAIL E
SCALE 5:24

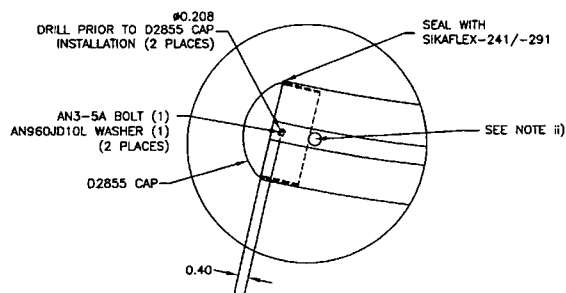


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SCALE 5:24

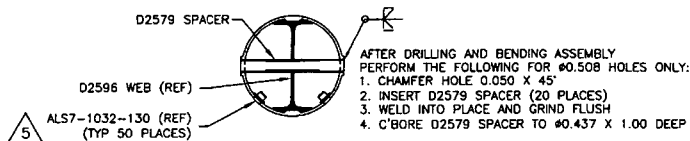


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07.06.28

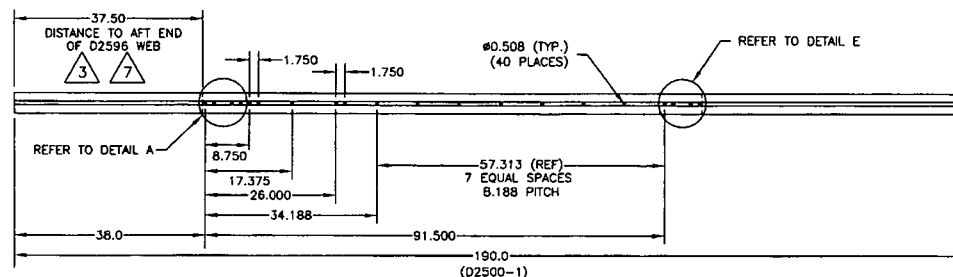
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SCALE 5:24



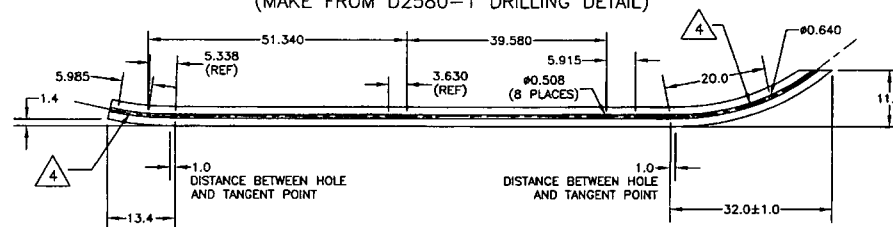
SECTION H-H
SCALE 5:24



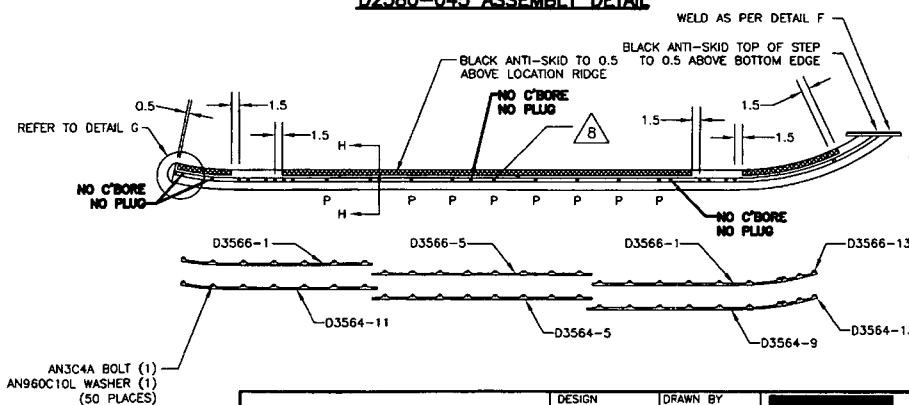
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

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| | | | |
|------------------|--------------------------------|----------------------|--|
| DESIGN RH | DRAWN BY RH | DART | DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA |
| CHECKED H | APPROVED H | DRAWING NO. D2580 | REV. 0 |
| DATE 07.02.27 | TITLE 205 SKIDTUBE ASSEMBLY | SHEET 3 OF 3 | SCALE 1:24 |

NO. 207

**AWS D17.1.2001
QUALIFICATION TEST RECORD**

Name: Barclay Elliott
Job number: 50849
Part number: D205-624-041
Description: 205 skt tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 09.08.27

Welder [Signature] Date of Test Coupon 09.08.27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld